

51

Date: Wednesday, 12/5/2007 8:01:04 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH
Job Number : 36106	
Estimate Number : 10274	
P.O. Number : <i>NIA</i>	Part Number : D350591312
This Issue : 12/5/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3272 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 35785	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 12/20/2007 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A 04.03.22 New issue KJ/RF	
Est Rev:B 07-06-09 Added D3572-1 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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(6)

1.0	DC	DOCUMENT CONTROL
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*KS 08-01-09*

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

*08/01/09*

2.0	D32721	STEP
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

STEP

BATCH: *3 36115**KS 07-12-06*

5

3.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate *335079**KS 07-12-06*

5

4.0	D32191	Support
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3219-1 Support *335591**KS 07-12-06*

5

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M105058  
M105844

3-Grind End Plate flush

*PE 07-12-06 5*  
*PE 07-12-06 5*  
*PE 07-12-06 5*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-12-07 (5)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PE 07-12-07 (5) RH*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Q.M 07-12-10 (5)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PE 07-12-11*

10.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3065-041 Step Leg Assy B33510

*PE 07-12-11 5*

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3066-1 Spacer B35692

*PE 07-12-11 5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 36106

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description:

12.0 MS20600AD4W4 Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number Description Batch  
16 MS20600AD4W4 Rivet M105953

*PE 07.12.11 5*

13.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Assemble Leg Assembly as per Dwg D3272.

*PE 07.12.11 5*

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PE 07.12.11 X5RH*

15.0 D30671 End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3067-1 End Plate 335074

*[Handwritten mark]*

*PE 07.12.11 5*

16.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M105058

4-Grind End Plate flush

*U.M 07.12.31 5*

5-Install last rivet.

*U.M 07.12.31 5 5*

*PE 07.12.11 5*  
*PE 07.12.11 5*  
*PE 07.12.11 5*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #: Machine Or Operation: Description :

17.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Log 01/02

XS  
702

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/02 (SRH)

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FL 08/01/02 (5)

20.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PRESSURE WASH  
M106379

BR 08-01-03 6.

FL 08/01/03 (5)

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

M106332.

FL 08/01/03 (5)

22.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

08/01/03 (SRH)

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0 D22303 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug 35800

AS 07/12/31

XS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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Job Number:



Seq. #: Machine Or Operation: Description :

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

35096

AS 09/12/31

(X5)

26.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 3.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip

35900

AS 09/12/31

(X5)

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

33249

AS 09/12/31

(X5)

28.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041

Support Assembly

36119

8/1/18 sep

29.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

M109408

AS 09/12/31

(X5)

30.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A

Bolt

M106242

AS 09/12/31

(X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36106

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 AN536A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt M106242

AS 07/12/31

32.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M105792

AS 07/12/31

33.0 AN960JD416 Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M105906

AS 07/12/31

34.0 AN960JD516 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M104156

AS 07/12/31

35.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M105558

AS 07/12/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 02/01/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36106

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M105054

AS 07/12/31

(45)

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

M105946

AS 07/12/31

X5

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/09 (45RH)

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location: B

08/01/09 (5)

40.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/09

Job Completion



08-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

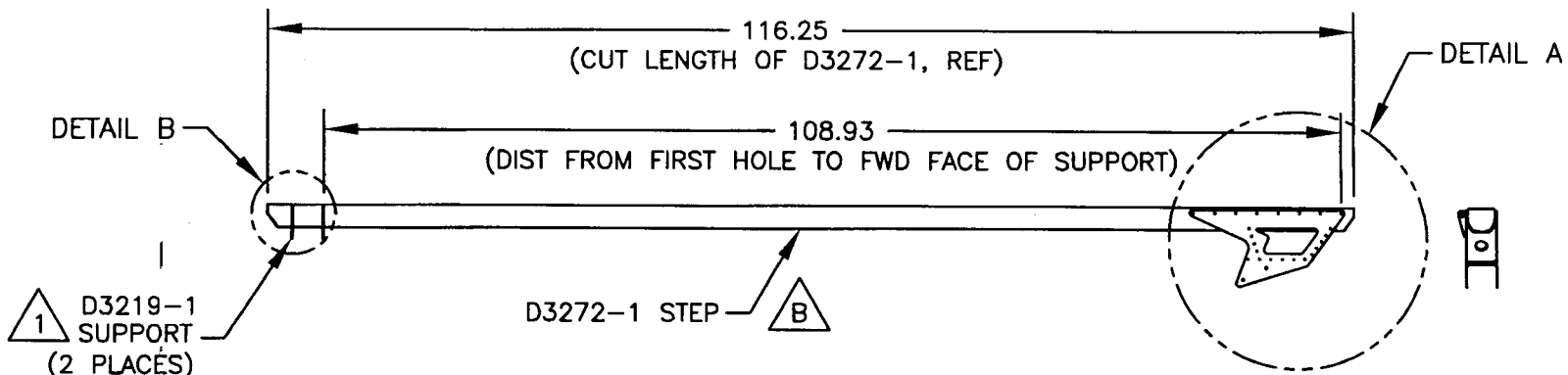
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *36106*

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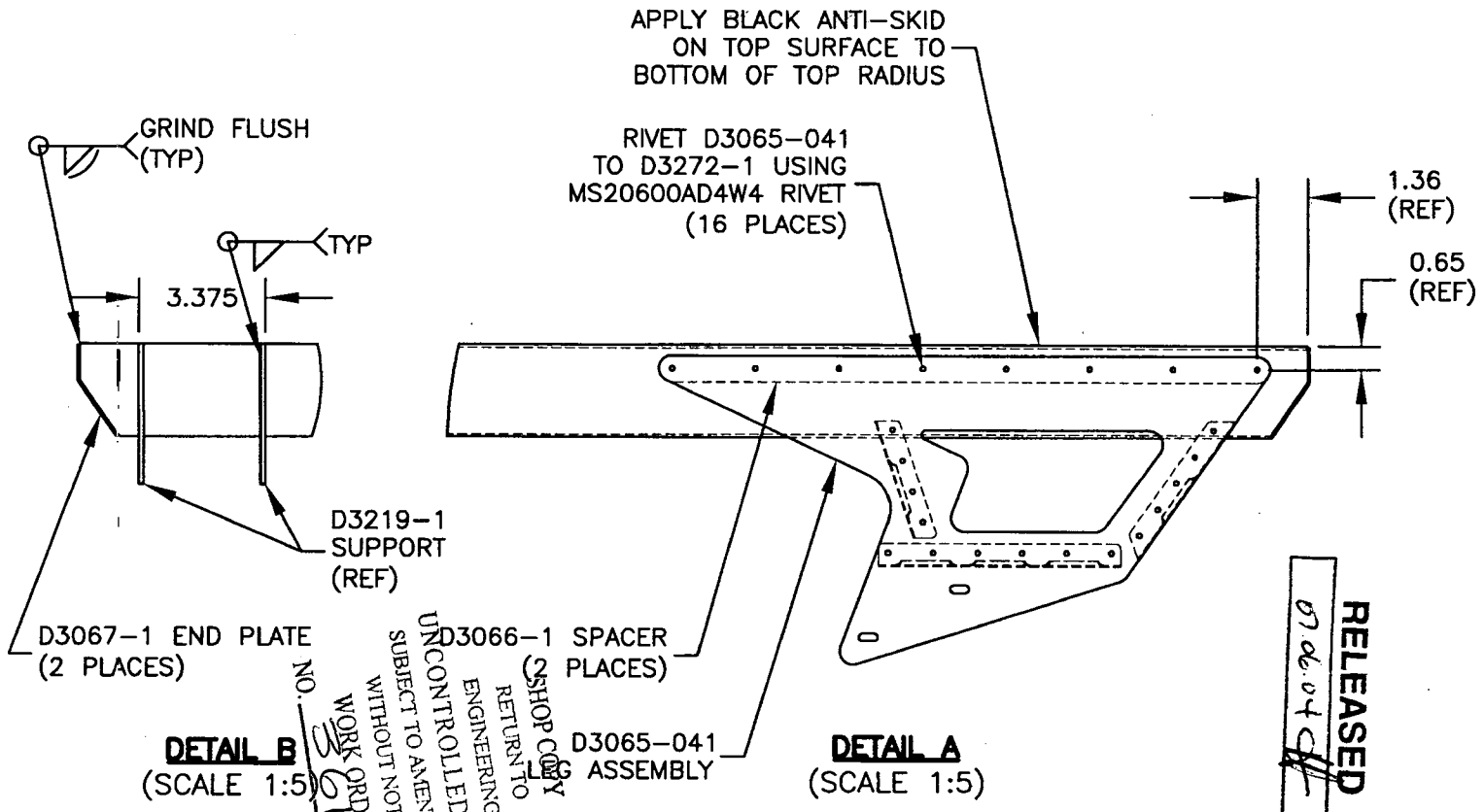
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DESIGN	q	DRAWN BY	q	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	q	REV. B
DATE	07.05.18	DRAWING NO.	D3272	SHEET 2 OF 3
		TITLE	STEP ASSEMBLY, HI LONG	SCALE
				1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



NO. 6106  
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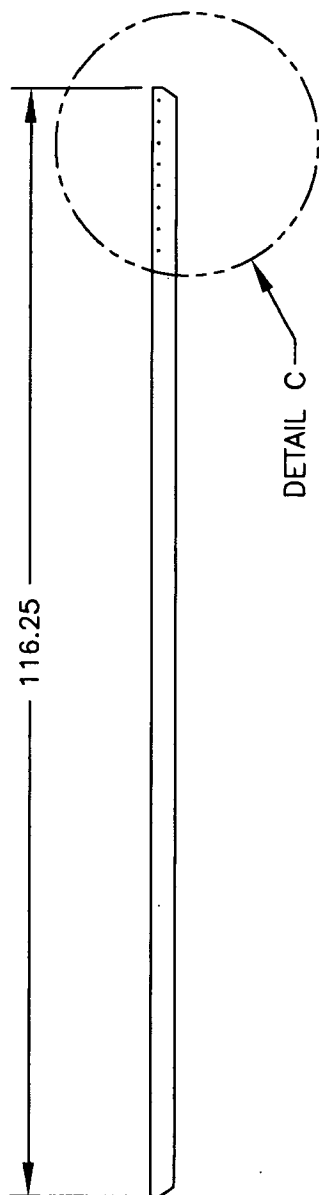




DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

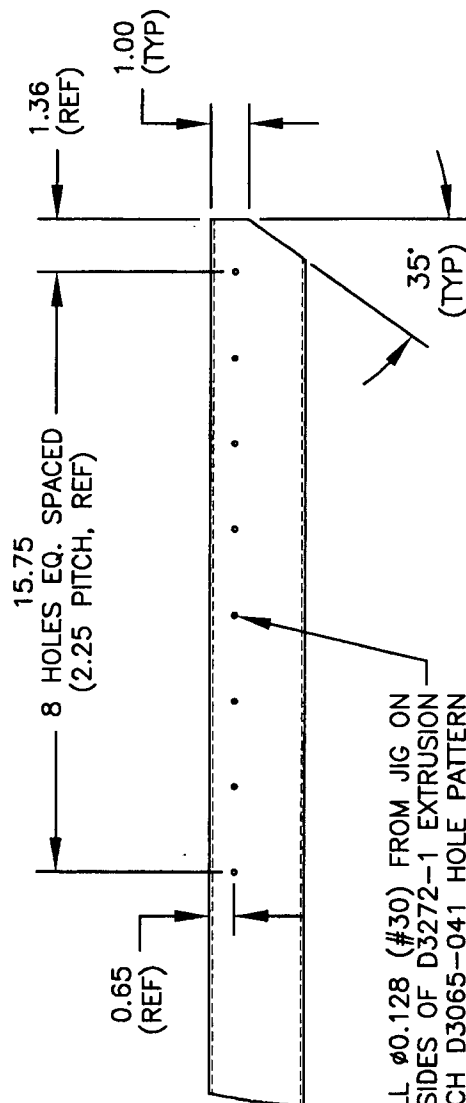
07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

DRILL Ø0.128 (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

SHOP COPY  
RETURN TO  
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WORK ORDER  
NO. *36106*

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Job Number : 36106	
Estimate Number : 10274	
P.O. Number :	Part Number : D350591312
This Issue : 12/5/2007 S.O. No. :	Drawing Number : D3272 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 35785	Material :
Written By : <u>[Signature]</u>	Due Date : 12/20/2007 Qty: 5 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A 04.03.22 New issue KJ/RF	
Est Rev:B 07-06-09 Added D3572-1 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

07.12.11 [Signature]

2.0	D32721	STEP
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

STEP

BATCH: \_\_\_\_\_

3.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate \_\_\_\_\_

REFERENCE ONLY

4.0	D32191	Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3219-1 Support \_\_\_\_\_